

Date: Monday, 02/03/2009 11:26:00 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM ASSEMBLY
<b>Job Number</b> : 46201	
<b>Estimate Number</b> : 13294	
<b>P.O. Number</b> :	<b>Part Number</b> : D3696041
<b>This Issue</b> : 02/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3696 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 44692	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/03/2009 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09.03.08</u>	
<b>Comment</b> : Est Rev:A New Issue 08-05-01 JLM Verified By:EC Est Rev:B 08-07-22 redesign part (prelim) DD verified by:EC Est Rev:C 09-02-20 rev.b asper dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M7075T6B1000X1000	7075 T6 BAR 1.00 x1.00
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**Comment:** Qty.: 1.5330 f(s)/Unit Total : 12.2640 f(s)

7075 T6 BAR1"x1"

Batch: M107984

SA 09/03/08

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank 17.750" long

SA 09/03/08 (8)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3696

2-Deburr as per dwg D3696

SS 09/03/08

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SS 09/03/08

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.L 09/03/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3696-041 PAR #: N/A Fault Category: Tool/Machined Parts NCR: Yes No DQA: D Date: 07/03/16  
 Resolution: Scrap D3780-041 D412-761-049 Disposition: Scrap QA: N/C Closed: D Date: 07/03/16

NCR: <u>46201</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/07	30	One part have big gouach after chamfer operation. Part came out of vise. R.C. operator error forgot to tight the vise lack of attention.	<u>DS/02</u>	- Scrap / no replace. - Ensure to tight all before operation.	<u>DS</u> 09/03/07	<u>DS/03/07</u>	<u>DS/04/2</u>	<u>DS/03-05</u>
					<u>DS/03</u>			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 46201

Part Number: D3696041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 09-03-10

(7)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*\* mask holes prior to powder coating as per dwg (see note 8)\*\*\*\*\*

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

14:05

OVEN TEMPERATURE:

320°

FINISH TIME:

14:35

ump/BL

09/03/10

(X7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-10

(X7)

9.0

D37991

Oilite Bronze Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Oilite Bronze Bushing

Batch: 44539x6 40735x1

FF 09-03-11

(7)

10.0

D38013

Hand Retractable Spring Plunger



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Hand Retractable Spring Plunger

Batch: 44538 / 40737x1

FF 09-03-11

(7)

11.0

MS21209C8 20

Heli Coil Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Heli Coil Insert

Batch: 100066

FF 09-03-11

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 11:26:00 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 46201

Part Number: D3696041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Helicoil

2-Press Bushing

3-Install Plunger

FF 09-03-11 (7)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 255

9/3/13

7x

SP

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 09/03/15

Job Completion



mf  
09-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

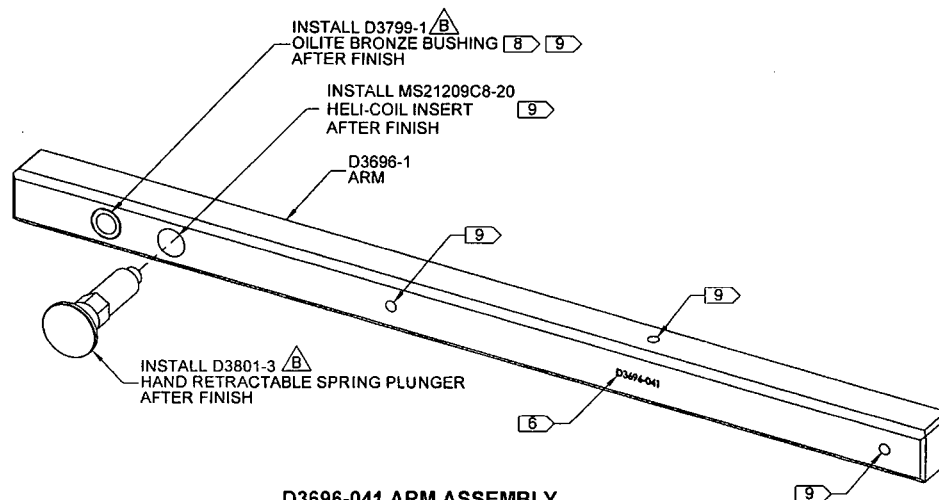
Part No: D3696-041 PAR #: N/A Fault Category: Prod / Fin Assy mod # 3mm NCR: Yes No DQA: D Date: 09/03/12  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/03/12

NCR: <u>46201</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>090311</u>	<u>120</u>	<u>The D3801-3 were installed on the wrong side. Opposite to the drawing.</u>	<u>[Signature]</u>	<u>Dis-Assemble &amp; re-install the D3801-3 plunger on the correct side. Qty 7. Ensure to correctly interpret the drawing. If not sure, ask.</u>	<u>FF</u> <u>09/03/12</u>	<u>[Signature]</u> <u>090312</u>	<u>[Signature]</u> <u>090312</u>	<u>[Signature]</u> <u>090311</u>

NOTE: Date &amp; initial all entries



QTY -041	P/N	DESCRIPTION
X	D3696-041	ARM ASSEMBLY
1	D3696-1	ARM
1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)
1	D3799-1	OILITE BRONZE BUSHING
1	D3801-3	HAND RETRACTABLE SPRING PLUNGER



**D3696-041 ARM ASSEMBLY**

**RELEASED**  
09/03/05

**D3696-041 NOTES:**

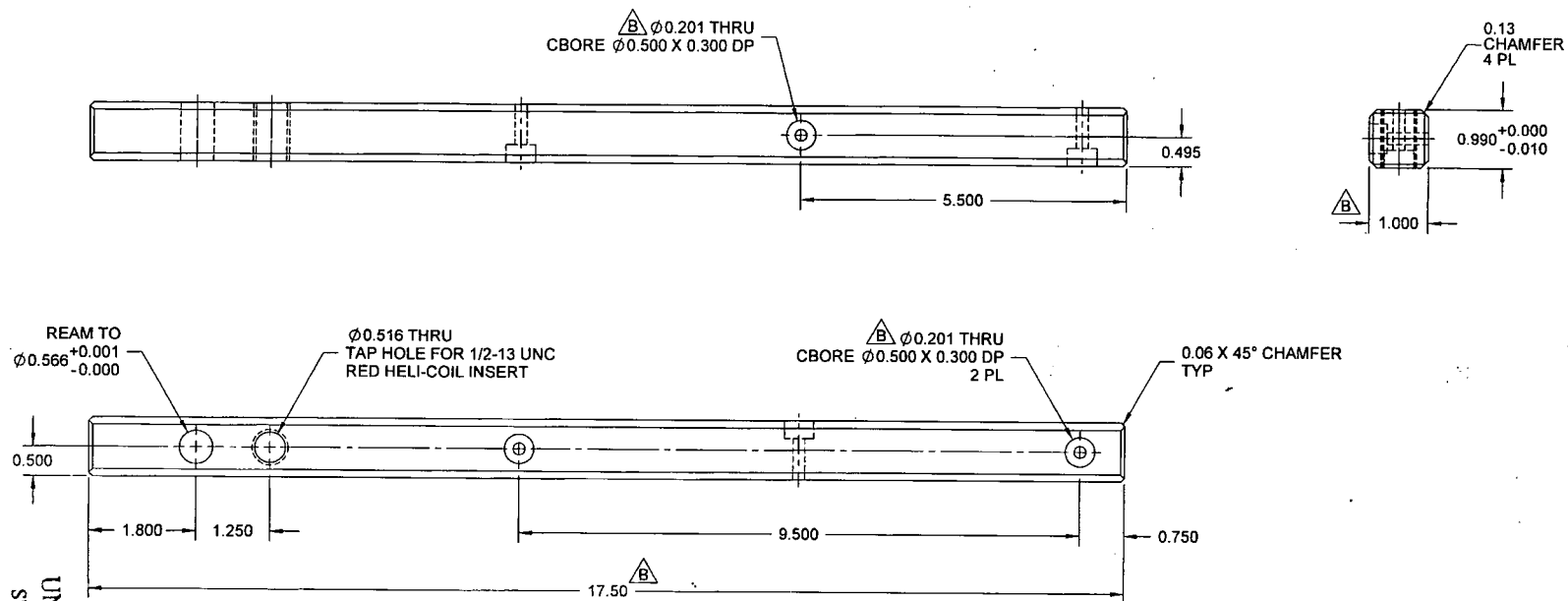
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

B	P/N D3799-1 WAS BNT-137 (ZN D5-1); P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED Ø0.201 HOLE AND CBORE (ZN C6-2 AND D5-2); 17.30 WAS 19.50 (ZN B5-2); 1.000 WAS 0.990 ±0.000/-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.17		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3696</b>	REV. B
TITLE <b>ARM ASSEMBLY</b>	SCALE NTS
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WITHOUT NOTICE  
WORK ORDER  
NO. 46201



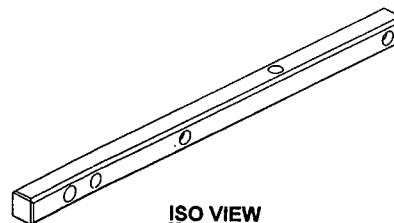


**D3696-1 ARM**





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**D3696-1 NOTES:**

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR  
 PER AMS-QQ-A-200/11  
 (REF. DART SPEC. M7075T6B)
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.62 lbs



**RELEASED**  
 09/05/02 MB

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MFG. APPR.		<b>D3696</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>ARM ASSEMBLY</b>	NTS
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